

Work Order ID 69151

Tuesday, May 03, 2011 12:53:35 PM

Page 1

Item ID: D350-636-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*P*

Date: 11-05-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	C								
IIN-D350-636	H								

02750 *M*

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-013 CHG 006

*Sub 6607*

*H* *for BG 11-6-7*

369151

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & <del>DT8863A</del> <sup>8864A</sup> for first side only <del>DT8863B</del> <sup>8864B</sup> for second side (detail B)								
	7- Clecko <del>DT8863B</del> <sup>8864B</sup> on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)								
	9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10- Open up holes of Detail A to 0.297" (total of 2 holes per side)								

BB

11/05/13

BB

11/05/16

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Customer:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004  
A/R Aluminum Rod batch: ☐ M116577 BE 11/05/17

12-Grind welds flush as per Dwg D2750  
BB 11/05/17

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

11.05.18

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11.05.18

W/O:		WORK ORDER CHANGES						
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				1	0		M 4/05/12
	Hand Finishing								
150	QC3- Inspect Part Finish	0.00							
	QC	0.00							11-5-25
	Quality Control								

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

2- Open holes section AV-AV 0.3125" (4 per side)

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: 11796 ☐☐☐  
exp. date: 12/1/15

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 10)

A/R ☐☐☐ Aluminum Rod batch: M117456

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

BB 11/05/25

BB 11/05/30  
11-5-30

BB 11/05/31

W/O:		WORK ORDER CHANGES						
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Required Date: 5/17/2011 Req'd Qty: 1.00

Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1X ~~Ø~~ m/4/06/01

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  Powdercoat Powder Coating M 116964	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 9:00 OVEN TEMPERATURE: 320 °F FINISH TIME: 9:30	0.00  0.00				12	0	M-L 11/06/06	
210  QC Quality Control	QC3- Inspect Part Finish  Memo ✓ Inspect for foreign object per QSI 024	0.00  0.00				1	0	M 11/06/06	
220  HandFinish Hand Finishing	HandFinishing  Memo ✓ 1-Install inserts as per dwg D2750	0.00  0.00				1	0	M 11/06/06	

W/O:		WORK ORDER CHANGES						
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
	HandFinish								
Hand Finishing	<b>Memo</b>	0.00							
	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>W/A</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>1116945</u> EXP DATE: <u>12/01</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>1114189</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>1114586</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	<b>Memo</b>	0.00							

1 p: 11/06/02

11/06/07

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  Packaging Packaging	Pick Kit  Memo	0.00  0.00							11/6/7 SP
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							8/10/07
270  Packaging Packaging	Packaging  Memo Package as per PPP D350-636-013	0.00  0.00							11/6/7 (2)

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Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C21106107

11/6/8 [Signature]

W/O:		WORK ORDER CHANGES						
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# Picklist Print

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Parent Item: D350-636-013

Parent Item Name: Skidtube LH



Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ  
 IPP rev I 06.03.30 Per rev. D dwg EC  
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec IPP Rev:L  
 10.06.22 revise seq110 DD verf:EC IPP Rev:M 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT 		Manufactured	No			110	Each	23.0000	1	1			
Extrusion Bent													

Location	Loc Qty	Loc Code
LG	23	
66874	1	
66875	8	
68137	10	
68138	4	

D3493-1 		Manufactured	No			110	Each	33.0000	2	2			
Washer													

Location	Loc Qty	Loc Code
ST062	33	
66975	33	

D2739 		Manufactured	No			160	Each	14.0000	1	1			
350 I Beam													

Location	Loc Qty	Loc Code
LG	14	
67785	2	
68285	6	
68286	6	
69538		

11/05/13  
 11/6/17

11/05/13

W/O:		WORK ORDER CHANGES							
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Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

160

Each

37.0000

1

1



Cap



BE 1/05/17

Location

Loc Qty

Loc Code

LG002

37

62715

8

65086

29

D3490-1

Manufactured No

160

Each

93.0000

4

4



Cross Bolt Spacer



BE 11/05/30

Location

Loc Qty

Loc Code

LG

91

67773

31

68105

60

LG001

2

62450

2

D3490-5

Manufactured No

160

Each

74.0000

4

4



Cross Bolt Spacer



BE 11/05/30

Location

Loc Qty

Loc Code

LG001

74

46490

18

59230

56

D2743

Manufactured No

220

Each

187.0000

8

8



Crossbolt Spacer



BE 11/05/30  
B 68948 21

Location

Loc Qty

Loc Code

LG001

187

67766

123

68251

64

87

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Shop Packet Print

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 69151

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,069.000

38

38



Handwritten: 1106106

Insert

Location

Loc Qty

Loc Code

FP-B

28

110768

28

x 38

ST282

1041

110768

1041

AN3C5A

Purchased

No

230

Each

1,332.000

34

34



Handwritten: 1106106

Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1325

115422

49

116419

376

x 34

116549

100

117343

500

117508

300

AN3C6A

Purchased

No

230

Each

300.0000

4

4



Handwritten: 1106106

BOLT

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

299

111982

2

116419

47

116549

50

116704

100

x 4

117514

100

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 12:53:41 PM

Page 4

Work Order ID: 69151

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

86.0000

4

4



BOLT



*u106106*

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

84

116874

4

117407

80

*x4*

AN8C35A

Purchased

No

230

Each

70.0000

1

1



BOLT



*u106106*

Location

Loc Qty

Loc Code

FP

40

117511

40

FP-A

30

115960

7

116874

23

*x1*

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38



washer

*na 117291*



*(x38) u106106*

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER

*NAS1149C0882R / M 114915*



*(x1) u106106*

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Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 69151

Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 5/3/2011



Required Date: 5/17/2011

Start Qty: 1.00



Required Qty: 1.00



D2745	Manufactured	No	230	Each	214.0000	8	8
							<u>xl</u> u106106
Bushing							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-A	214	
67764	13	
<u>68248</u>	201	

D3488-041	Manufactured	No	230	Each	4.0000	1	1
							<u>xl</u> u106106
Blade Fitting Assembly, LH							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP007	1	
61689	1	
FP008	3	
62002	3	

D3492-1	Manufactured	No	230	Each	0.0000	8	8
							<u>xl</u> u106106
Plug							

D3492-5	Manufactured	No	230	Each	0.0000	8	8
							<u>xl</u> u106106
Plug							

D3535-25	Manufactured	No	230	Each	18.0000	1	1
							<u>xl</u> u106106
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP018	18	
62233	1	
65167	6	
<u>68353</u>	11	

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Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 12:53:42 PM

Page 6

Work Order ID: 69151

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

37.0000

1

1



Gasket



*Handwritten: 11/06/06*

Location

Loc Qty

Loc Code

FP012

37

65903

11

68351

26

*Handwritten: x1*

D3537-1

Manufactured No

230

Each

39.0000

3

3



Wearpad



*Handwritten: 11/06/06*

Location

Loc Qty

Loc Code

FP017

39

63313

2

66135

33

66935

4

*Handwritten: 1368944*

*Handwritten: x2*

*Handwritten: vj*

D3631-1

Manufactured No

230

Each

500.0000

8

8



Washer



*Handwritten: 11/06/06*

Location

Loc Qty

Loc Code

ST072

500

68062

500

*Handwritten: 1263417*

*Handwritten: x8*

D3791-1

Manufactured No

230

Each

8.0000

1

1



Wearplate



*Handwritten: 11/06/06*

Location

Loc Qty

Loc Code

FP017

8

62239

8

*Handwritten: 11*

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 7

Work Order ID: 69151

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230 Each

15.0000 1



Wearshoe



1

4/26/06

Location

Loc Qty

Loc Code

FP018

15

61710

1

64445

14

21

D3793-3

Manufactured No

230 Each

23.0000 1



Wearshoe



1

4/26/06

Location

Loc Qty

Loc Code

FP018

13

68356

13

FP019

10

64447

10

21

D3794-1

Manufactured No

230 Each

33.0000 1



Gasket



1

4/26/06

Location

Loc Qty

Loc Code

FP010

33

39279

1

39421

1

61704

5

68355

26

1361312

21

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 12:53:43 PM

Page 8

Work Order ID: 69151

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230 Each

35.0000

1

1



Gasket



u1 u106106

Location

Loc Qty

Loc Code

FP010

26

68357

26

FP018

9

39422

1

61712

8

u1

MS21043-6

Purchased No

230 Each

527.0000

4

4



u1 u106106

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

44

112314

44

ST301

463

112314

463

u1

MS21083C8

Purchased No

230 Each

91.0000

1

1



u1 u106106

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

117423

50

u1

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Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 12:53:43 PM

Page 9

Work Order ID: 69151

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

216.0000

8

8



O-RING



Handwritten: 11/06/06

Location

Loc Qty

Loc Code

FP002

216

106099

111

114220

105

Handwritten: 11/06/06

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING



Handwritten: 11/06/06

Location

Loc Qty

Loc Code

FP

80

117460

80

FP-A

186

110915

139

115589

47

Handwritten: 11/06/06

AN8C21A

Purchased

No

260

Each

78.0000

2



BOLT



Location

Loc Qty

Loc Code

ST345

78

116381

28

117562

50

Handwritten: 11/06/06

AN960JD816

Purchased

No

260

Each

45.0000

2



1/2" washer, Alum



Handwritten: 11/06/06

Location

Loc Qty

Loc Code

FP-A

45

106043

45

Handwritten: 11/06/06

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Page 9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 12:53:43 PM

Page 10

Work Order ID: 69151

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

260 Each

45.0000

1



Blade, 350 Skidtube



1

Location

Loc Qty

Loc Code

ST466

45

61341

7

63589

38

D3672-1

Manufactured No

260 Each

1,379.000

8



Phenolic Washer



1

8 4

all ulocloc

Location

Loc Qty

Loc Code

FP-A

29

52505

29

ST074

1350

64177

850

66821

500

x 4

MS21083C8

Purchased No

260 Each

91.0000

2



NUT



2

116175

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

117423

50

2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-046	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 49151  
PO 11-05-13

RELEASED  
6-27-22

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

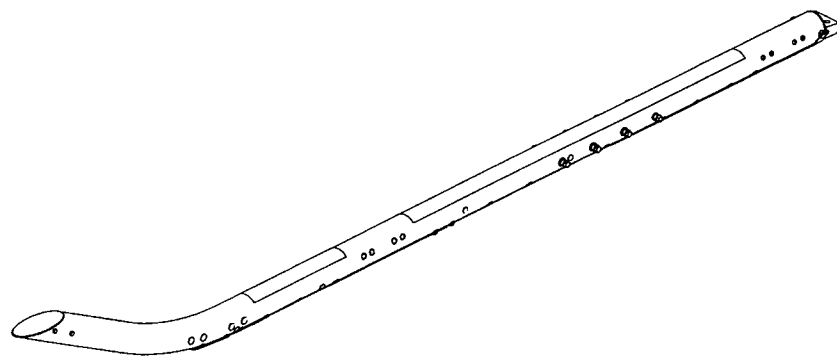
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

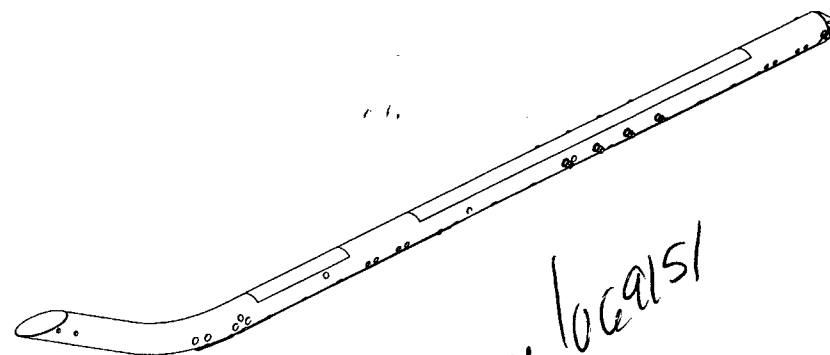
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

*u loc 9151*

**RELEASED**  
28-9-22/11

DESIGN	<i>PC</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D2750</b> REV. F SHEET 2 OF 11 TITLE <b>350 SKIDTUBE ASSEMBLY</b> SCALE <b>NTS</b>
DRAWN	<i>AM</i>	
CHECKED	<i>AM</i>	
MFG APPR.	<i>AM</i>	
APPROVED	<i>AM</i>	
DE APPR.	<i>AM</i>	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

*u'loc9151*

**RELEASED**  
68-9-22/111

DESIGN	Pol	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	Pol	PORT HADLOCK, WA	
CHECKED	Pol	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

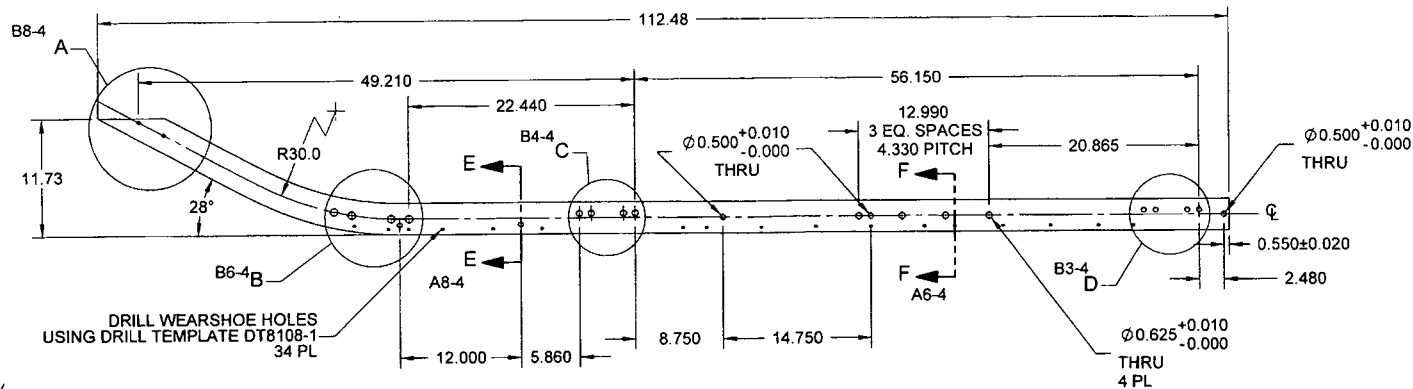
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

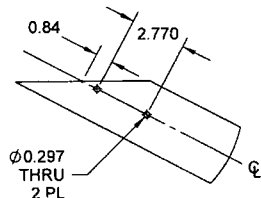
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

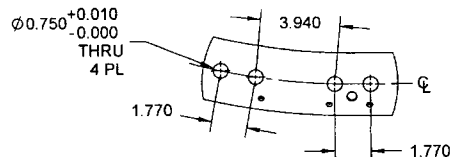
**NOTE:** Date & initial all entries



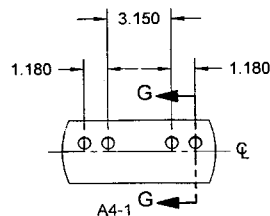
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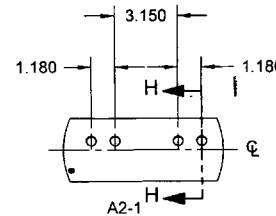
**DETAIL A**  
SCALE 2X



**DETAIL B**  
SCALE 2X



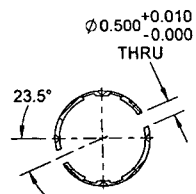
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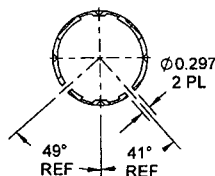
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*W/069151*

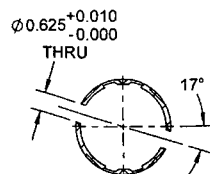
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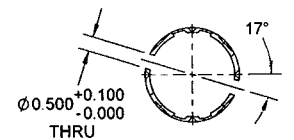
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	IPB
DRAWN	IPB
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO. <b>D2750</b>	REV. F SHEET 4 OF 11
TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

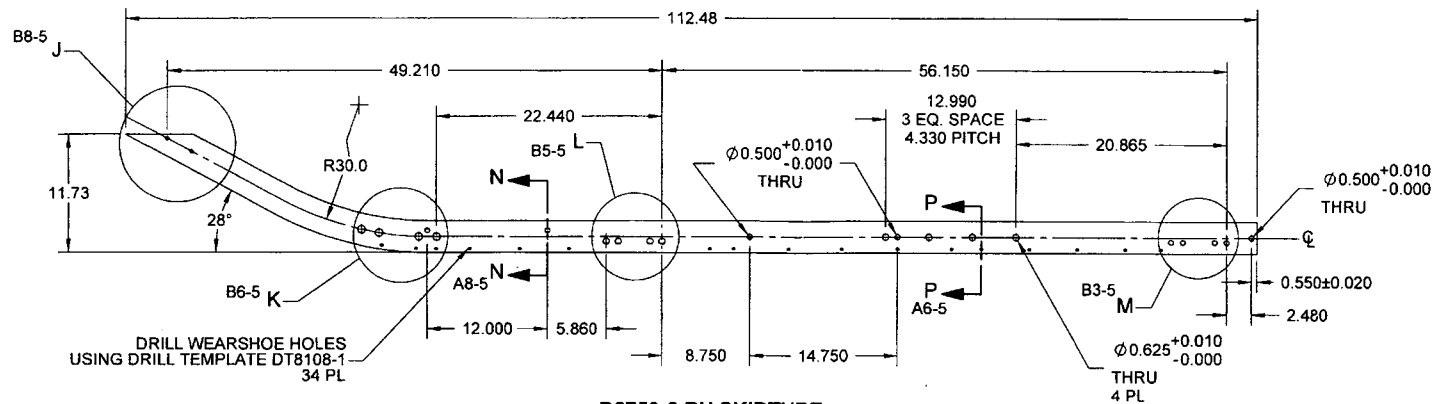
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

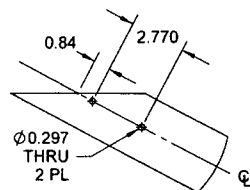
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

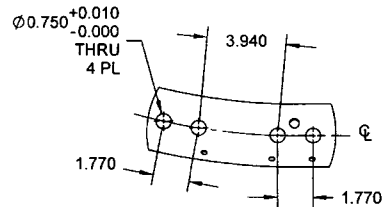




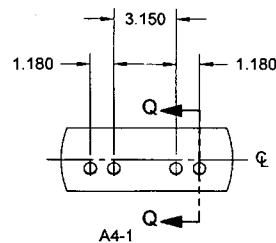
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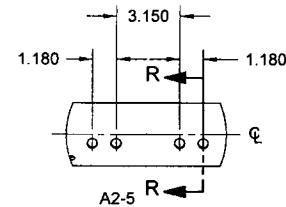
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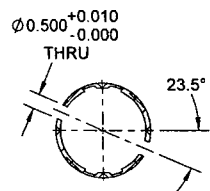
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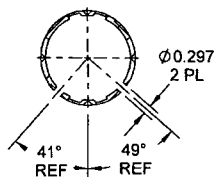
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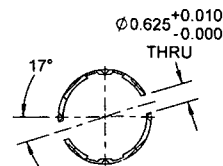
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SCALE 2X



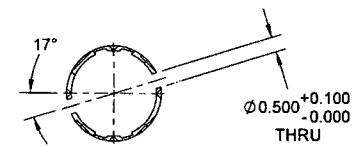
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN	REV	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

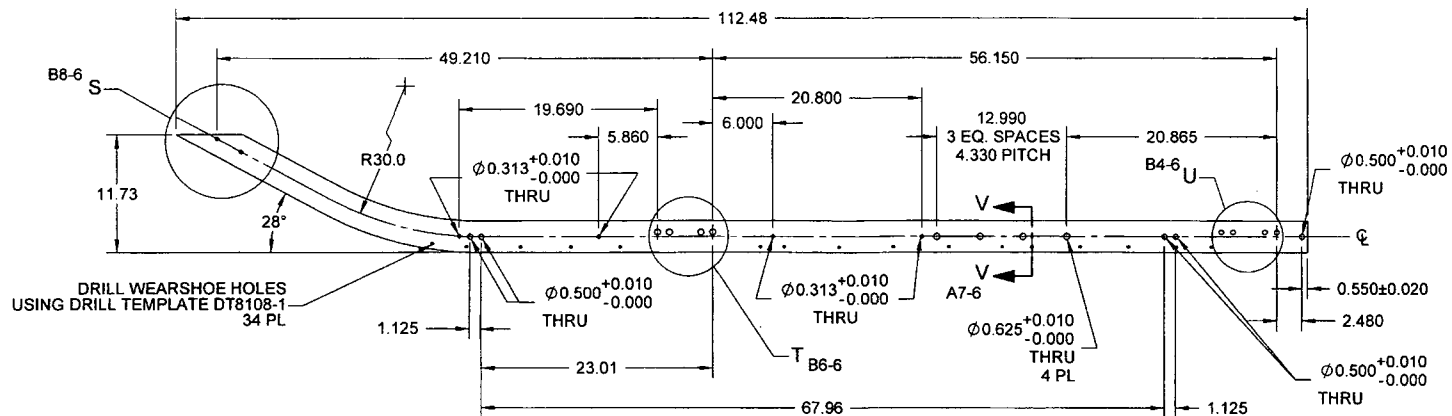
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

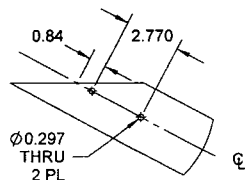
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

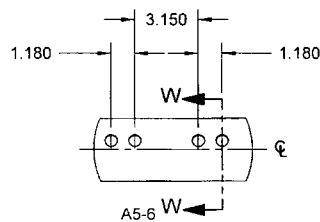
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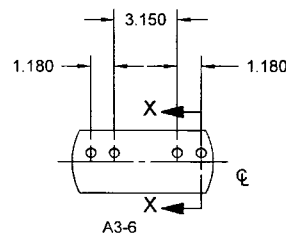
**D2750-3 LH SKIDTUBE**



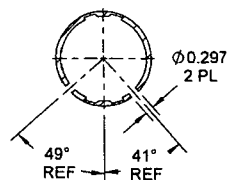
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SCALE 2X



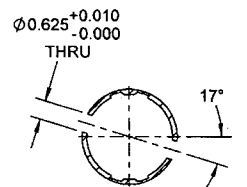
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SCALE 2X



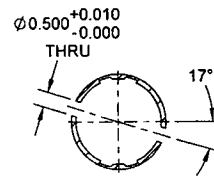
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL









**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

*w/069151*

**RELEASED**  
08-22-11

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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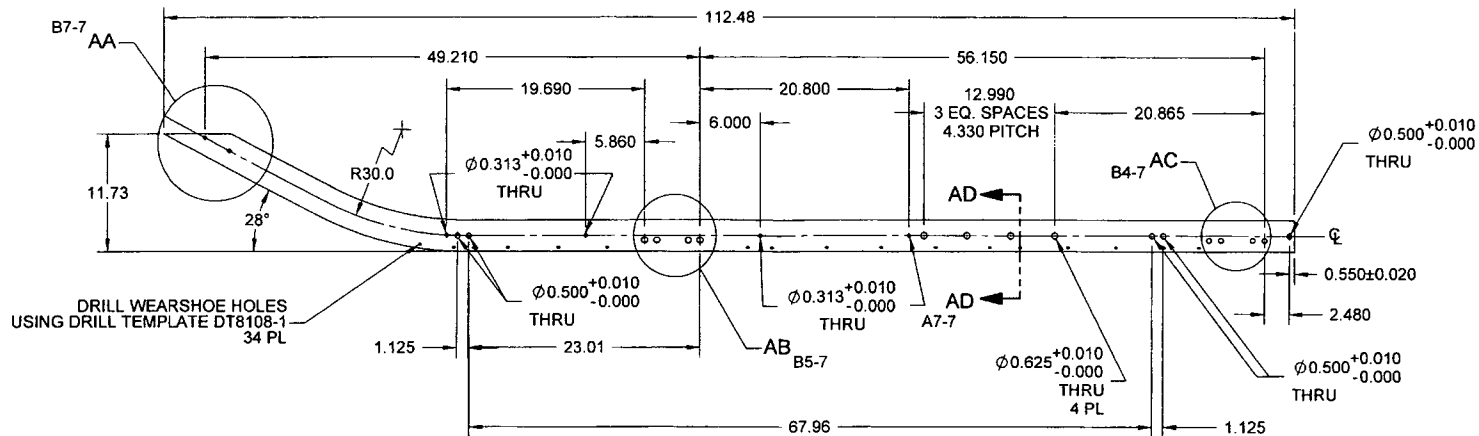
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

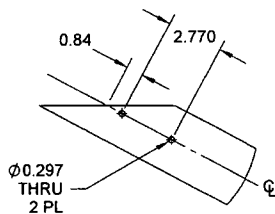
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

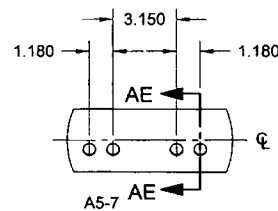
**NOTE:** Date & initial all entries



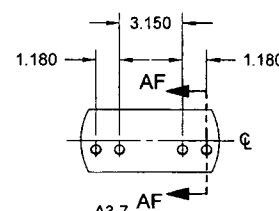
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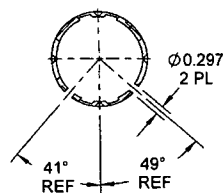
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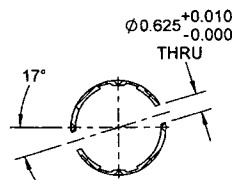
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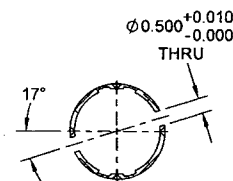
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

*u 106915*

**RELEASED**  
06-04-22-116

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. F
APPROVED		SHEET 7 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE <b>NTS</b>

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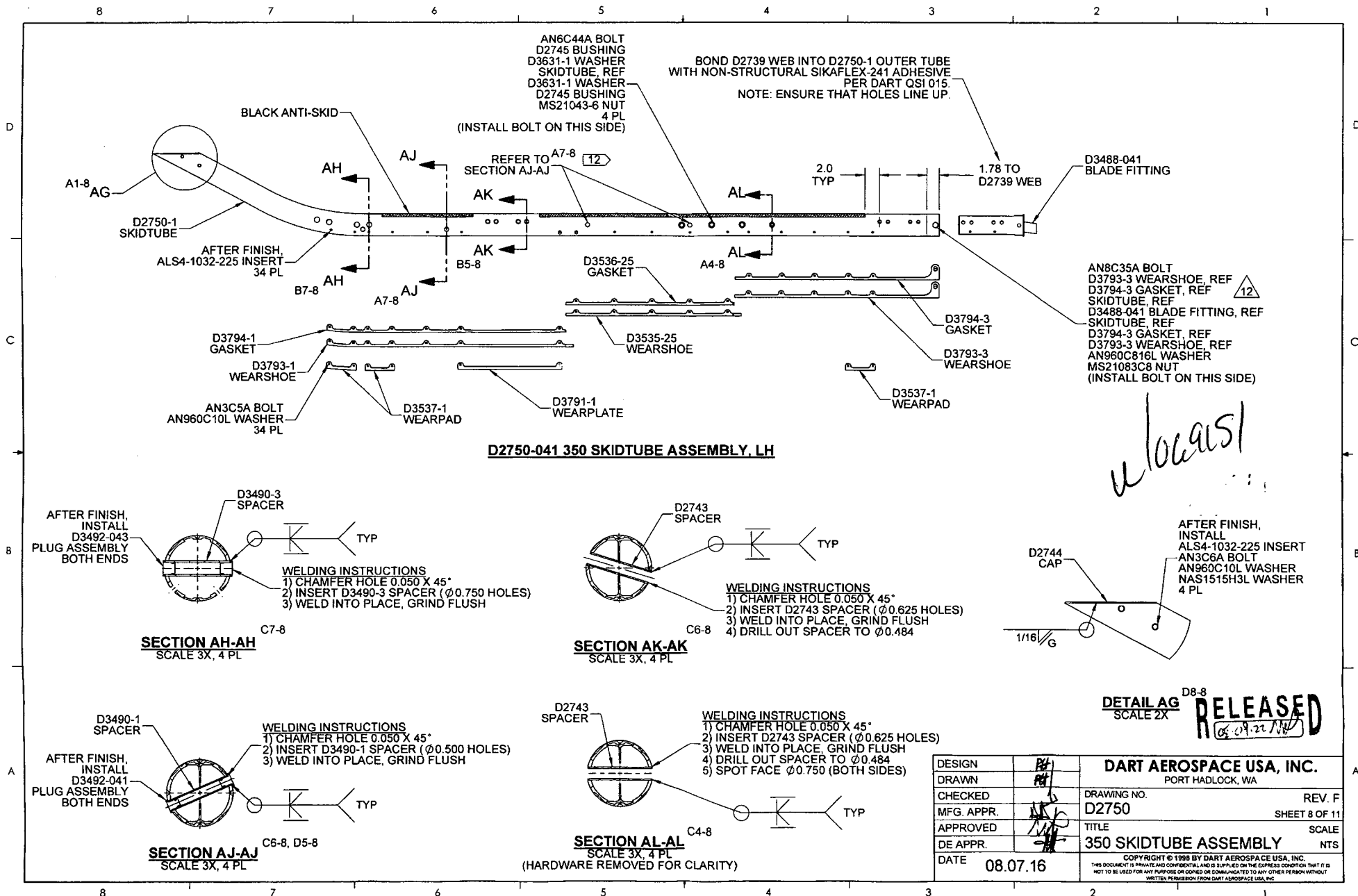
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

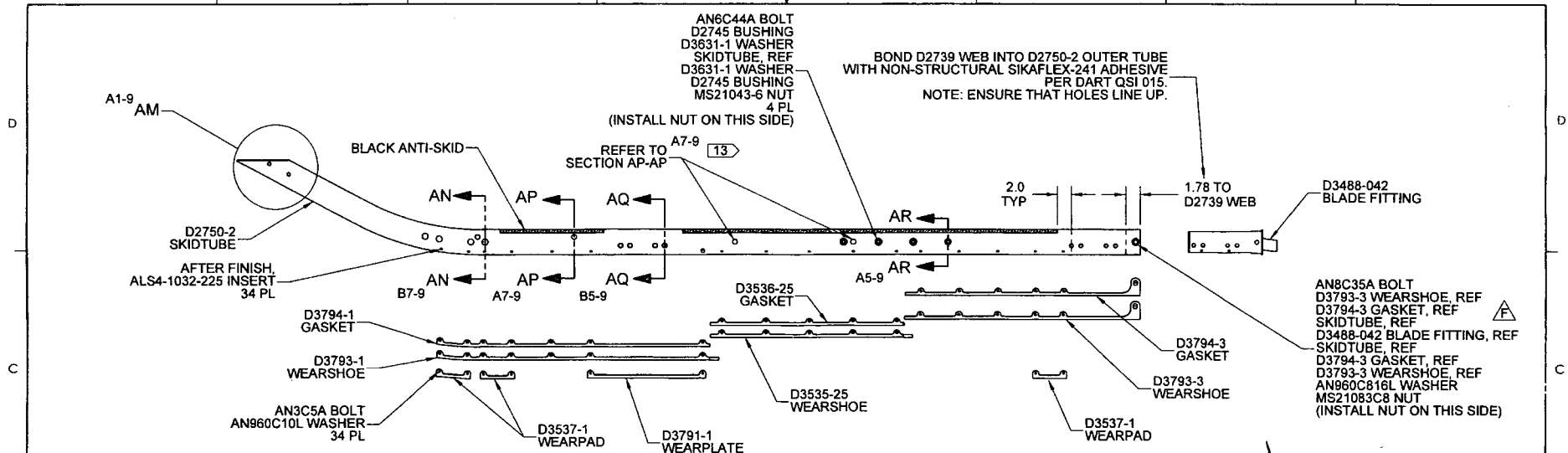
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

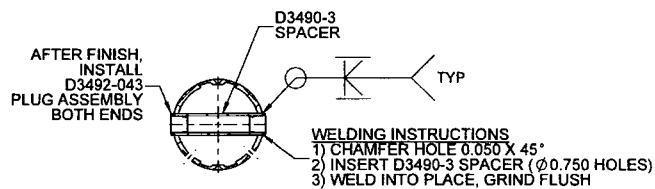


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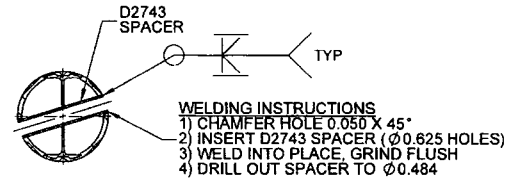


# **D2750-042 350 SKIDTUBE ASSEMBLY, RH**

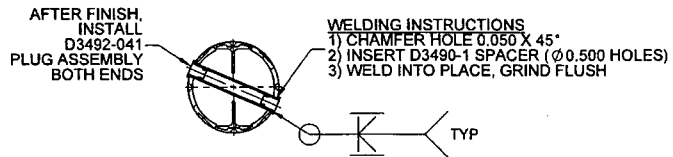
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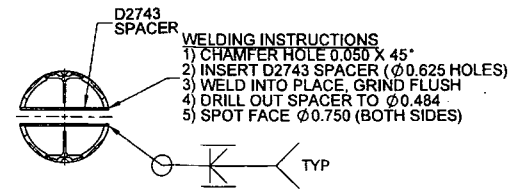
## **SECTION AN-AN** SCALE 3X, 4 PL



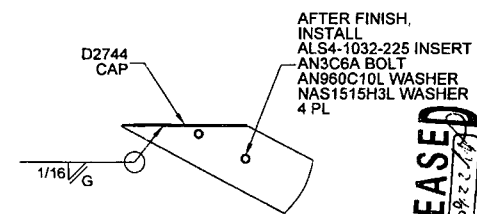
## **SECTION AQ-AQ** SCALE 3X, 4 PL



## **SECTION AP-AP** SCALE 3X, 4 PL



## **SECTION AR-AR** SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



## **DETAIL AM** SCALE 2X

DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	<b>D2750</b>	SHEET 9 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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08-09-22-16

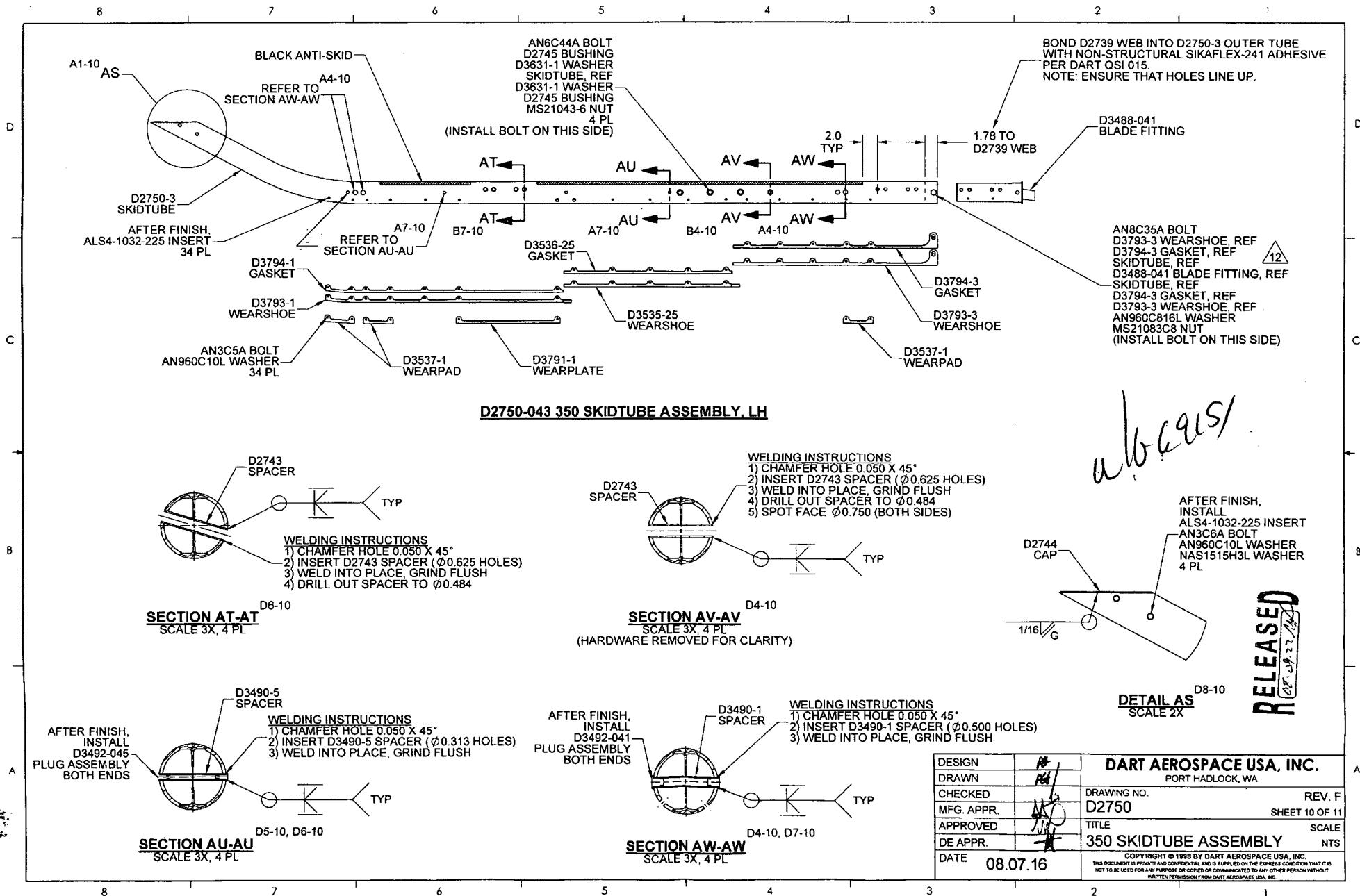
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries



DESIGN	AS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

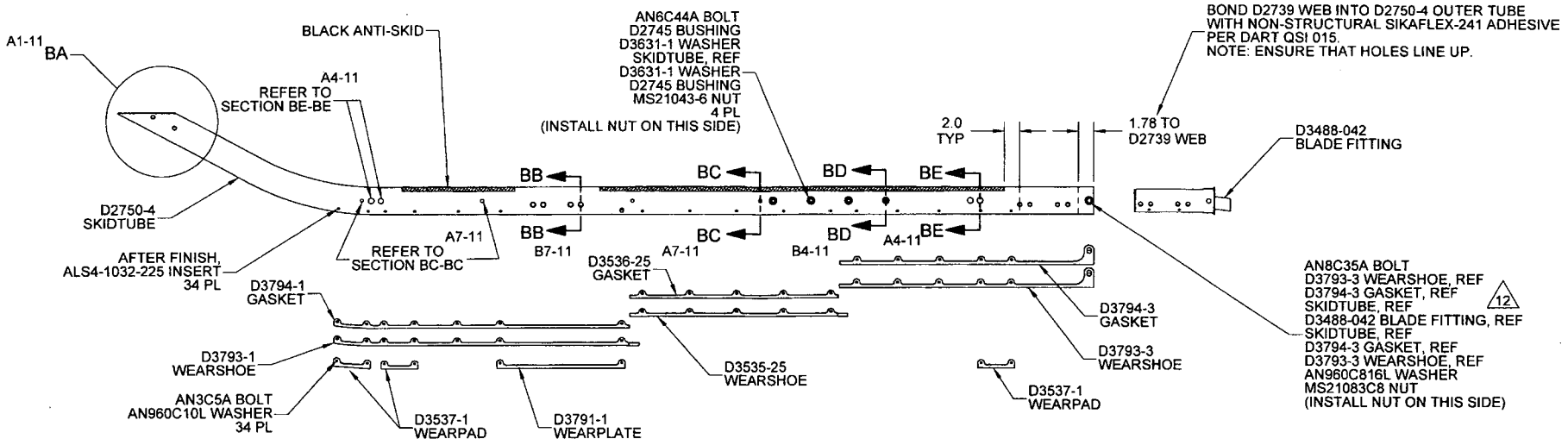
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

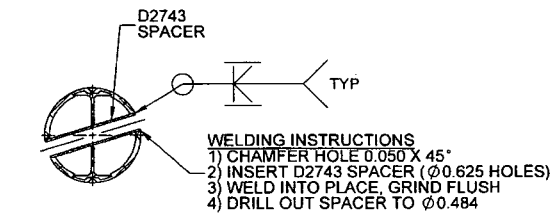
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

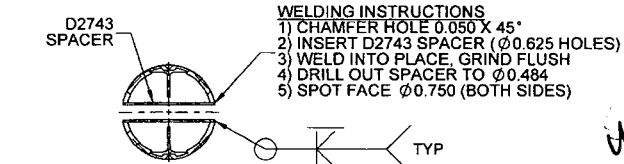
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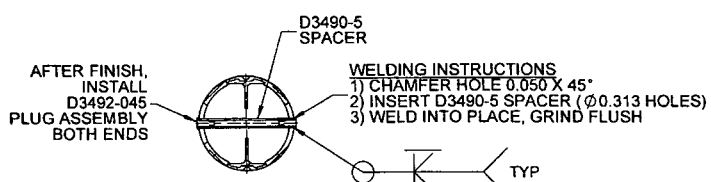
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



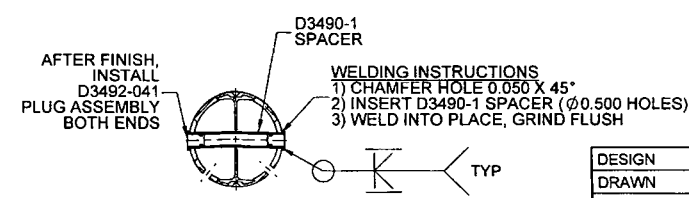
**SECTION BB-BB**  
SCALE 3X, 4 PL



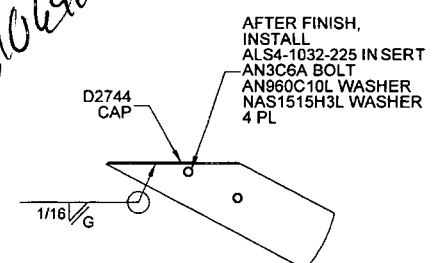
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

**RELEASED**  
06-07-22

DESIGN	18	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	18	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

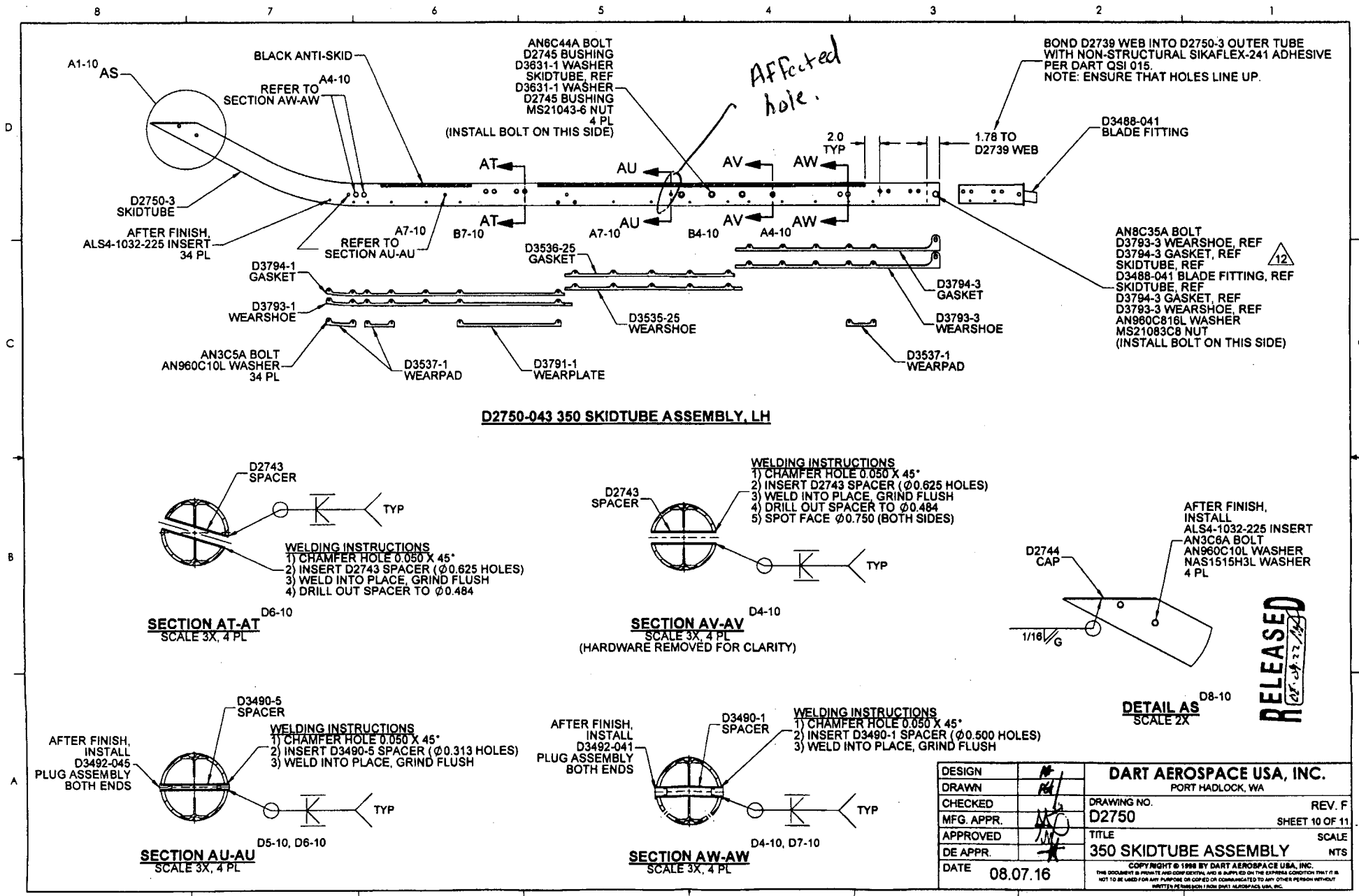
**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-013 PAR #: N/P (Process) Hard tubes Fault Category: CARELESSNESS NCR: Yes No DQA: A Date: 11.06.14  
 11-651 Resolution: Re-work Disposition: Re-work QA: N/C Closed: X Date: 11/06/15

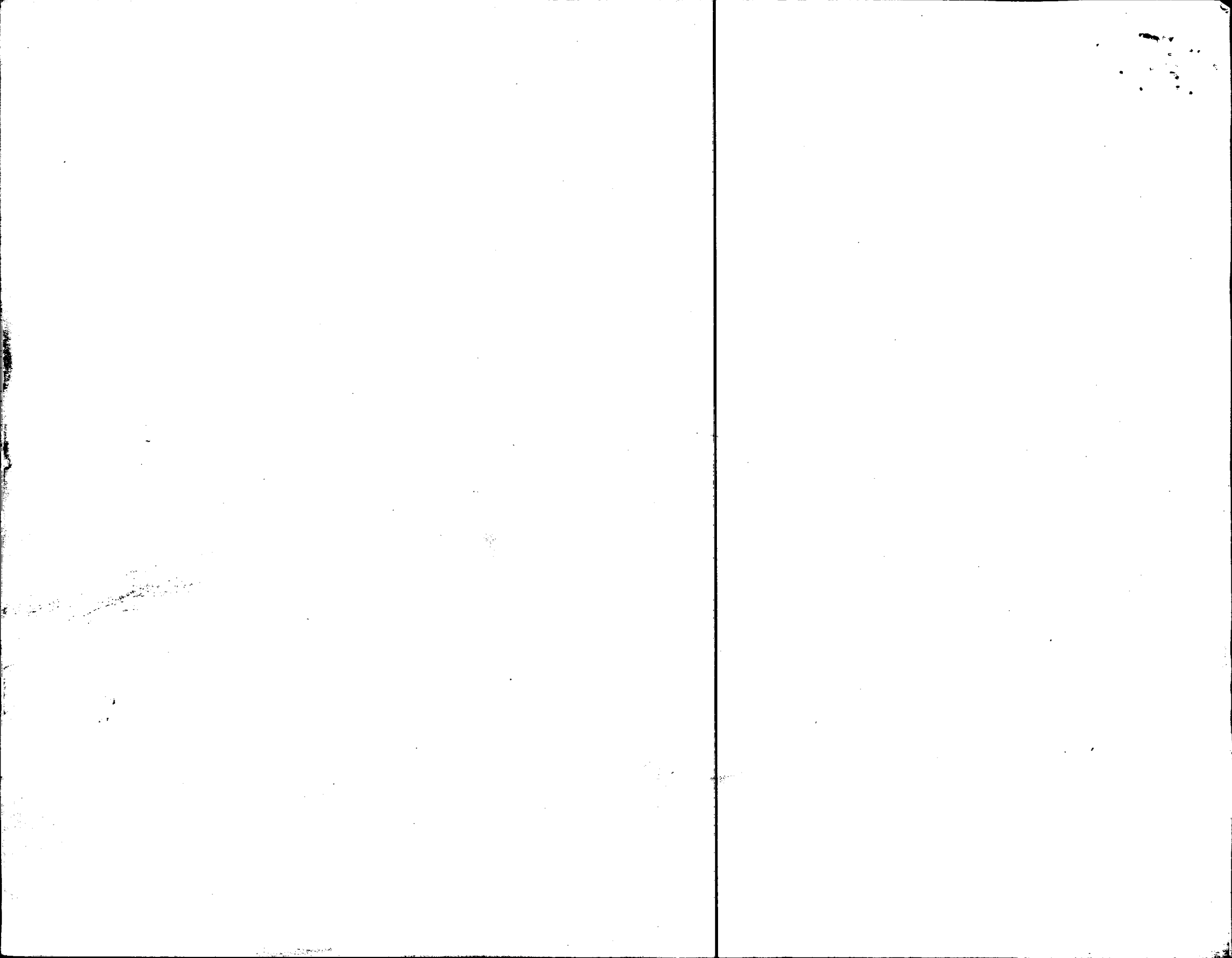
NCR: <u>69151</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.05.24	# 160	Ø 0.313 HOLE (NEXT TO MID FLAT HOLES) WAS DRILLED Ø 0.500  L.C. LACK OF ATTENTION	<u>Q</u> 11.05.24 <u>PS/042</u>	INSTALL Ø 0.500 O.D. x Ø 0.196 I.D. CROSSBOLT SPACER: M6X16T, M6X16T. B/N <u>M117379</u> 3.085 ± 0.030 LONG	<u>BE</u> 11/05/30	<u>S</u> 11/06/01	<u>Q</u> 11.05.24 <u>PS/042</u>	<u>S</u> 11/06/01

NOTE: Date & initial all entries



DESIGN	<i>MS</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>MS</i>	PORT HADLOCK, WA	
CHECKED	<i>MS</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>MS</i>	D2750	SHEET 10 OF 11
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	350 SKIDTUBE ASSEMBLY	NTS
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NO. 253

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 67621  
Part number: D350 636 011  
Description: 350  
Welding Process: Tig~~h~~☒ Mig[ ]  
Base material: Aluminium  
Current: AC~~h~~☒ DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass~~h~~☒ fail[ ]  
Penetration: pass~~h~~☒ fail[ ]

UNACCEPTABLE

Cracks: pass~~h~~☒ fail[ ]  
Undercut: pass~~h~~☒ fail[ ]  
Pin holes: pass~~h~~☒ fail[ ]  
Overlap (cold lap): pass~~h~~☒ fail[ ]  
Porosity (surface): pass~~h~~☒ fail[ ]  
Coloration: pass~~h~~☒ fail[ ]

Qualifier Rob Green Date of Test Coupon 11.05.19  
Welder Barclay Elliot Date of Test Coupon 11.05.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld